

Work Order ID 79479-2

January-26-12 1:09:25 PM

Split - Already Costed #

79479

Page 1

Item ID: D2492

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Patient Stop

Start Date: 26/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M L J

Date: 12/01/2012

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2492

Rev G

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

6061 - 080

1-Cut as per Dwg D2492

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

B12-2-6

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-6

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/2/07

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79479

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Item ID: D2492 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Patient Stop
 Start Date: 26/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Debur Form using Jig DT2492B	0.00 0.00				5			8/6 12/10/01
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Smb 12/10/01	9/10/01 17/10/01		5			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	Smb	12/10/02	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79479


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Item ID: D2492 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Patient Stop
 Start Date: 26/01/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						5	0	12/10/02	
QC	Memo	0.00							
Quality Control									
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170						5	X		mf
Powdercoat	Memo	0.00							12/10/02
Powder Coating	START TIME: 2:45 OVEN TEMPERATURE: 320°F FINISH TIME: 3:15								
180	QC3- Inspect Part Finish	0.00							
180						5	X		mf
QC	Memo	0.00							12/10/02
Quality Control									

m121878

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D2492

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Patient Stop

Start Date: 26/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

0.00

Packaging

12/10/4 sel

200

QC21- Final Inspection - Work Order Release

0.00


200

QC

Memo

0.00

Quality Control

12/10/4 

CMF
12-10-4

Inv.
Adj.
already
costed

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-26-12 1:09:29 PM

Page 1

Work Order ID: 79479

79479

Parent Item: D2492

D2492

Parent Item Name: Patient Stop

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP E00.06.26Removed P/O for powder coatEC

IPP Rev:F Now 6061-T6 06-06-23 JLM

IPP Rev:G now water jet 07-12-11 DD

10.09.24 as per revG DD verf:EC

IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	390.3000	1.8229	11.51305		19.	
M6061T6S 080										**		B12-2-6	
6061-T6 .080 Sheet													

Location

MAT021

Loc Qty

390.3

117285

7.3

119009

3.5

119766

187.5

120349

192

Loc Code

119766

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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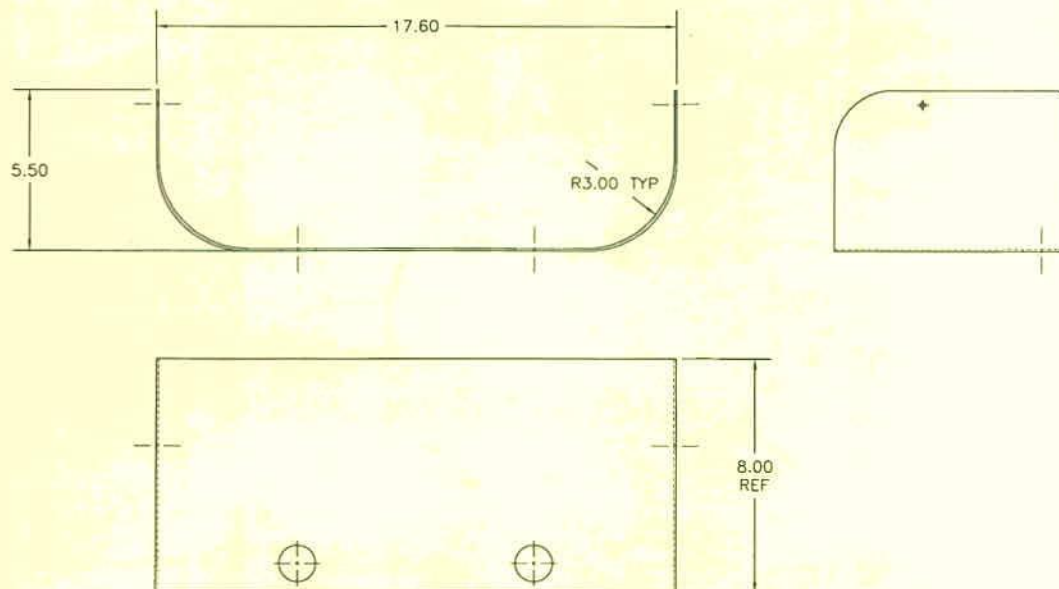
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NOTE: Date & initial all entries



D2492 PATIENT STOP
(MAKE FROM D2492F)

NOTES:

- 1) MATERIAL: MAKE FROM D2492F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2492" AND B/N PER QSI 044 6.5
- 7) WEIGHT: 1.6 lbs

SHOWN IN
RETURNED
ENGINEER
UNCONFIRMED
SUBJECT TO APPROVAL
WITHIN 30 DAYS
WORK IN PROGRESS
NO 79479 M.C.J
12/01/26

RELEASED
2010-09-21

REV.	DESCRIPTION	BY	DATE
G	REDRAW, ADD FLAT PATTERN, 2 PL WAS 4 PL (ZN C3-2), NCR 10-062	CP	10.08.10
F	Ø1.25 WAS Ø1.020	MB	06.09.14
E	ADD 6061-T6 MAT., R3.0 WAS R4.00, 5.50 WAS 6.00	CB	06.05.30
D	R4.00 WAS R2.00, ADD 8" WIDTH DIM.	KE	98.05.11
C	CHANGES MATERIAL AND FINISH	KE	97.07.14
B	MINOR CHANGES	BW	96.02.28
A	NEW ISSUE	BW	95.10.24
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2492 TITLE PATIENT STOP SCALE NTS REV. G SHEET 1 OF 2 COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	KE		
CHECKED	KE		
MFG. APPR.	KE		
APPROVED	KE		
DE APPR.	KE		
DATE	10.08.10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

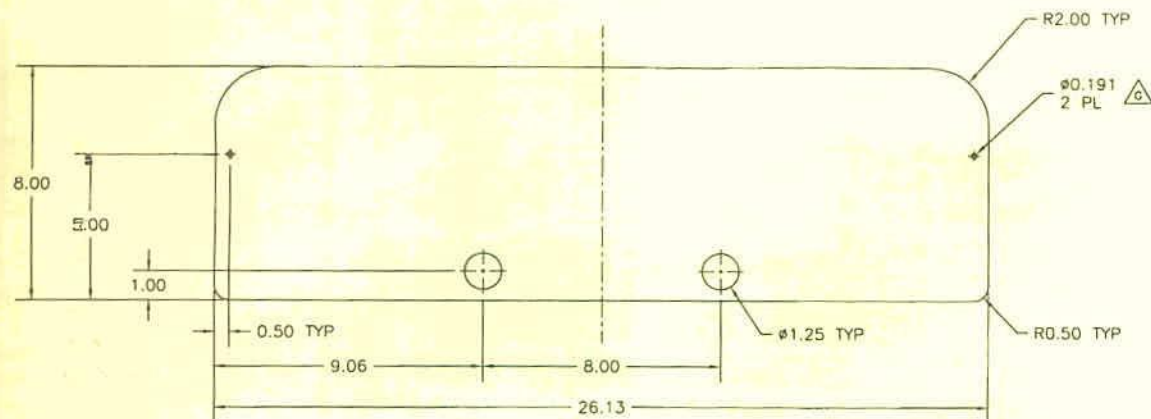
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NOTE: Date & initial all entries

79479



D2492F FLAT PATTERN

RELEASED
2010-09-20

NOTES:

- 1) MATERIAL: 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11, AMS-QQ-A250/11, AMS 4025, AMS 4027, OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2492	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PATIENT STOP	NTS
DATE	10.08.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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